

Work Order ID 141991

Tuesday, February 23, 2016 11:23:10 AM

141991

Page 1

Item ID: D3802-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Windows Seal (\$ Per Foot)
Start Date: 2/23/2016 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 3/11/2016 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: MCS Date: FEB 23 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3802	D								

100	PURCHASING	0.00				50	FEB 23 2016	DAS 13 9-89
100								
Purchasing	Memo	0.00						
Purchasing	Issue P/O: <u>31460</u>							
	Purchase Part Number: 93695K58							
	Supplier: Mc MASTER-CARR							
	Certificate of conformity is required							
110	Receive & Inspect for Damage & Mat'l Certs	0.00				(50)	DAS 6 9-89	 FEB 26 2016
110								
Packaging	Memo	0.02						
Packaging	Ensure material certification is attached							
120	QC6- Inspect dimensions to drawing	0.00				(50)	DAS 38 9-89	FEB 26 2016
120								
QC	Memo	0.00						
Quality Control	Ensure Material certification comply to Dwg D3802							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>54410</u>	0.00							
130									
Packaging	Memo	0.01				<u>SD</u>	<u>DAS</u>		
Packaging							<u>6</u>		
							<u>9-89</u>		<u>FEB 20 2016</u>
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.08				<u>MLJ</u>			<u>MAR 01 2016</u>
Quality Control									

MLJ MAR 01 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

Picklist Print

Tuesday, February 23, 2016 11:23:13 AM

Page 1

Work Order ID: 141991

141991

Parent Item: D3802-1

D3802-1

Parent Item Name: Windows Seal (\$ Per Foot)

Start Date: 2/23/2016

Required Date: 3/11/2016

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A 09-01-12 rev.A as per dwg DD verified by:ec
IPP Rev:B 09-04-15 rev.b as per dwg DD verified by:EC IPP Rev:C
10.08.04 p/n chg per ECN10-568 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
93695K58		Purchased	No			110	f	0.0000	1	50			
93695K58										**			
WINDOW SEAL													

DAS
6
9-89

FEB 26 2016

DQA: _____ Date: _____



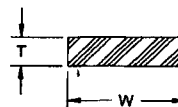
WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
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Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
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Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

SPECIFICATION CONTROL DRAWING



D3802-X-YYY WINDOW SEAL
WHERE YYY REPRESENTS LENGTH

DART P/N	SUPPLIER	SUPPLIER P/N	T THICKNESS	W WIDTH
D3802-1-YYY	McMASTER-CARR	93695K58	0.25	1.00

EG: 0.25" X 1.00" X 40" WINDOW SEAL = D3802-1-040
0.25" X 1.00" X 120" WINDOW SEAL = D3802-1-120

END OF COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

0.141991 ML5
16-02-23

RELEASED
2011-11-25

NOTES:

- 1) MATERIAL: 'PEEL AND STICK' NEOPRENE/EPT/SBR BLEND CLOSED CELL SPONGE, MEDIUM DENSITY
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

D	CORRECTED P/N EXAMPLE FOR CUT LENGTH OF 40"; ADDED EXAMPLE FOR CUT LENGTH OF 120" ZN B3-1). REASON: PART11-100.	MB	11.11.22
C	CHANGE SUPPLIER P/N TO 93695K58 PER FLAMMABILITY TEST RESULTS	MB	10.06.30
B	CHANGE SUPPLIER P/N TO 93695K88 PER FLAMMABILITY TEST RESULTS	MB	08.12.18
A	NEW ISSUE	MB	08.08.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3802	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		WINDOW SEAL	NTS
DATE	11.11.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO31460
Order Placed By
Chantal Lavoie

Page 1 of 2
02/24/2016

McMaster-Carr Number
7543512-03

Line	Product	Ordered	Shipped
1	92198A672 18-8 Stainless Steel Hex Head Cap Screw, 7/16"-14 Thread, 5" Long, Packs of 1	120 Packs	70
2	7566K25 Cable Tie Mount, Adhesive/Fastener Mount, 4 Way, 0.21" Tie WD. , White, Packs of 50	1 Pack	1
4	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10	5 Packs	5
5	93695K58 Oil-Resistant Neoprene/Vinyl/Buna-N Foam, Adhesive-Back, 1/4" Thick, 1" Width, 50' L, Black	1 Each	1
6	6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size	10 Each	10
8	4443A33 12-Volt Lithium Ion Battery for, Milwaukee Cordless Tool	1 Each	1
10	5682A81 Premium Plastic-Handle Screwdriver, 1/4" Tip Width, 4" Long Slotted Round Blade	2 Each	2
11	5443A28 Miniature Inch Combination Wrench, 12 Point, 5/16" Size, 3-1/2" Overall LG. , Chrome Finish	2 Each	2
12	3672K17 Steel Precision V-Groove-Guided Track Roller, Standard Stud, 20 mm Roller Diameter	3 Each	3
13	99142A540 Black-Finish Steel Internal Retaining Ring, for 1-1/2" Bore Diameter, Packs of 25	1 Pack	1
14	8635K171 Medium-Strength Oil-Resistant Buna-N Rubber, Plain Back, 1" Thick, 12" X 12", 50A Durometer	1 Each	1
15	7856K15 Heat-Shrink Tubing, 1/4" ID Before, 1/8" ID After, 4' L, Black	1 Each	1
16	7856K16 Heat-Shrink Tubing, 3/8" ID Before, 3/16" ID After, 4' L, Black	1 Each	1
17	7856K14 Heat-Shrink Tubing, 3/16" ID Before, 3/32" ID After, 4' L, Black	1 Each	1
18	7196K41 Straight-Blade, Three-Blade Female Connector, NEMA 5-15	3 Each	3
19	4429K154 Low-Pressure Brass Threaded Pipe Fitting, 3/4 Pipe Size, 90 Degree Female X Male Elbow	4 Each	4
20	4568K194 Standard-Wall Brass Threaded Pipe Nipple, 3/4 Pipe Size X 3" Length	2 Each	2
21	47865K24 Brass Ball Valve, 3/4" NPT Female Connections	2 Each	2
22	73605T93 Brass Garden Hose-to-Pipe Rigid Adapter, 3/4" Male Garden Hose, 3/4" NPT Female Connections, Packs of 1	2 Packs	2

16/12/2016
Sig

ART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31460**

Purchase Order Date 2/23/2016

PO Print Date 2/24/2016

Page Number 2 of 9

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Purolator ground ppd

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

USD

FCA - (Free Carrier)

4 92311A639

SS SET SCREW

2/26/2016

Yes

2/26/2016

50.00

Each

Line Total:

\$104.32

AS PER DWG D2747 REV. B
B141990

\$0.63

\$31.30

5 93695K58

WINDOW SEAL

2/26/2016

Yes

2/26/2016

50.00

f

Line Total:

\$31.30

AS PER DWG D3802 REV. D
B141991

\$0.31

\$15.40

6718K52

Fitting, Quick Disconnect

2/26/2016

Yes

2/26/2016

10.00

Each

Line Total:

\$15.40

AS PER DWG D4182 REV. B
B141986

\$5.81

\$58.10

162/26
SP

Note:

2/24/2016